

# Work Order ID 71972

Thursday, July 14, 2011 12:38:55 PM



Page 1

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Upper Rib Assembly

Start Date: 7/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4034

B

100

Weld per dwg A/R S.S. rod Batch: 1115778 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

11.07.20 (3)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 11.07.20

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 21 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71972

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Item ID: D4034-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Upper Rib Assembly

Start Date: 7/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD

11-07-21

3

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/21

ME

11-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 14, 2011 12:38:52 PM

Page 1

Work Order ID: 71972

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 7/14/2011


Required Date: 7/20/2011

Start Qty: 3.00

Required Qty: 3.00


Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as  
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER  
DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4034-1  Rib		Manufactured	No			100	Each	20.0000	1	3		11.07.20	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--


Location	Loc Qty	Loc Code
----------	---------	----------

WA	20	
67334	20	

D4034-3  Rib		Manufactured	No			100	Each	3.0000	1	3		11.07.20	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	3	
58408	0	
67338	3	

D4021-7  Hoop		Manufactured	No			100	Each	4.0000	1	3		11.07.20	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	4	
56996	0	
70339	4	

71743 -1

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 14, 2011 12:38:52 PM

Page 2

Work Order ID: 71972



Parent Item: D4034-041



Parent Item Name: Aft Upper Rib Assembly

Start Date: 7/14/2011

Required Date: 7/20/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-9

Manufactured No

100

Each

94.0000

4

12



Bushing

*11.07.20*

Location

Loc Qty

Loc Code

WA

92

68063

28

70333

64

WA005

2

66437

2

*12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

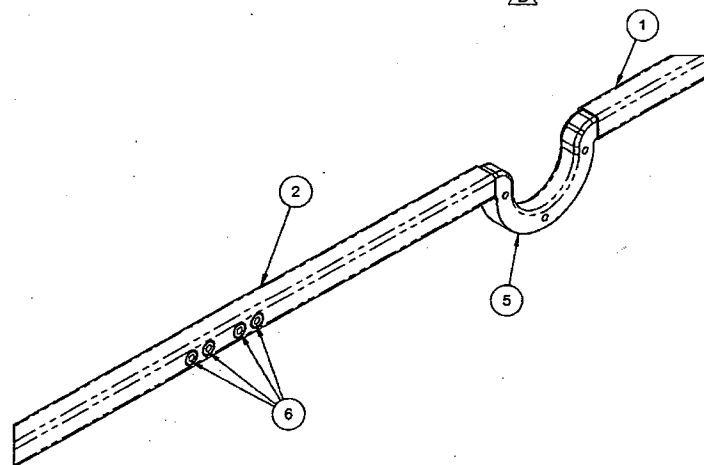
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

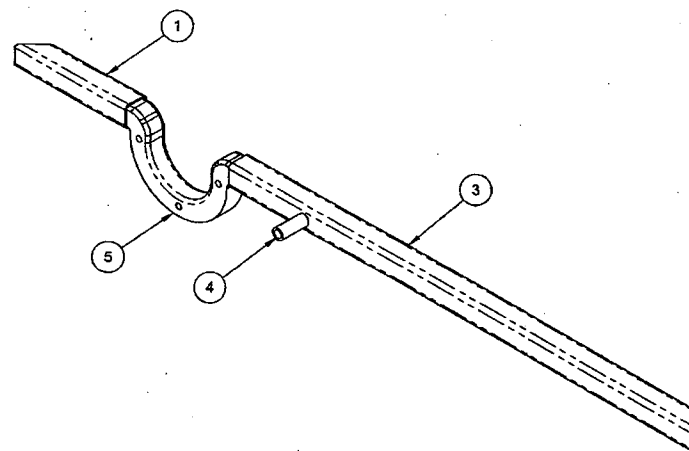
**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



**D4034-041 AFT UPPER RIB ASSY**



**D4034-043 FWD UPPER RIB ASSY**

CL11107114  
W10.71972

RELEASED  
2011-01-18  
MB

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	SC		
CHECKED	B		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.20		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

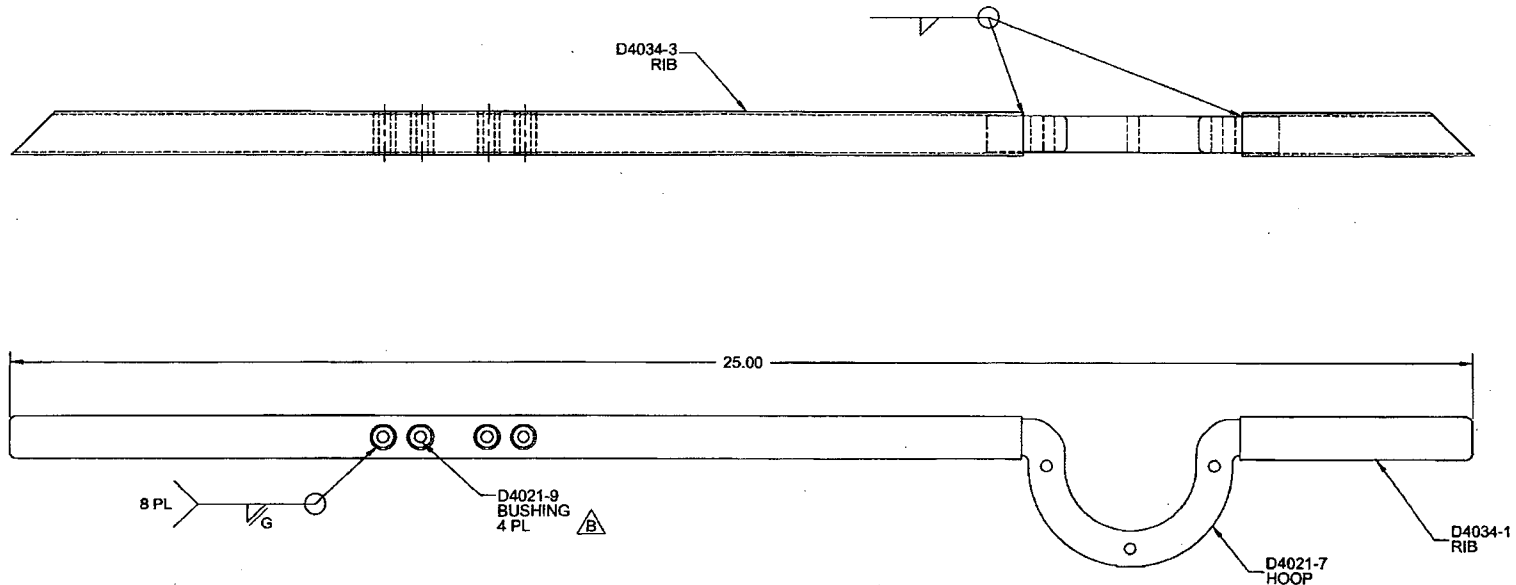
DRAWING NO.  
**D4034**

REV. B  
SHEET 1 OF 4

TITLE  
**UPPER RIB ASSY, BASKET BASE**

SCALE  
NTS

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**D4034-041 AFT UPPER RIB ASSY**

**RELEASED**  
 2011-01-18

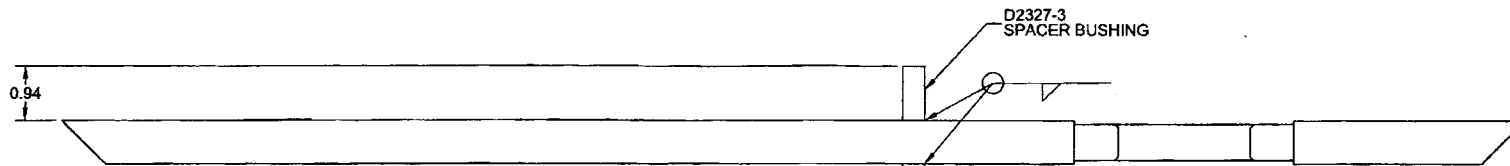
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 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.61 lbs  
 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	<b>D4034</b>	SHEET 2 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
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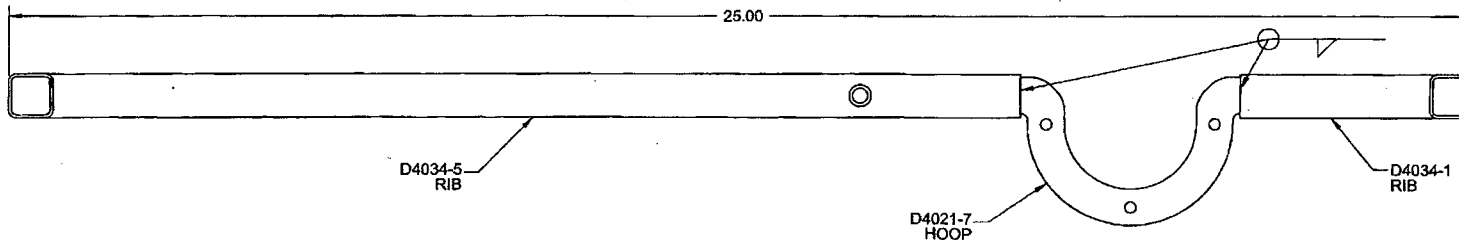
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C

C



B

B

**D4034-043 FWD UPPER RIB ASSY**

RELEASED  
2011-01-18

**NOTES:**

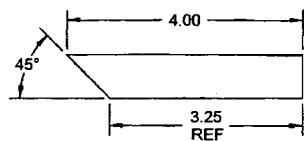
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
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APPROVED	h	TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

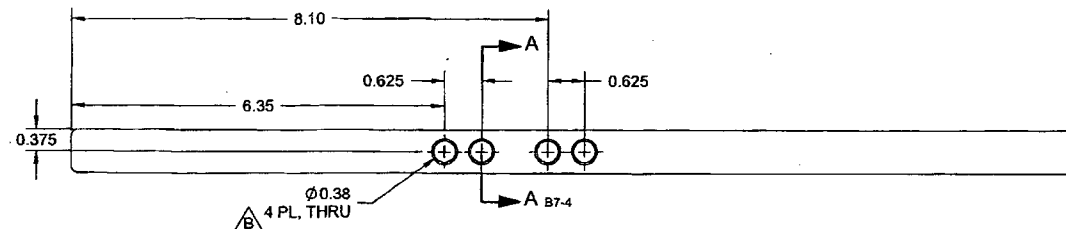


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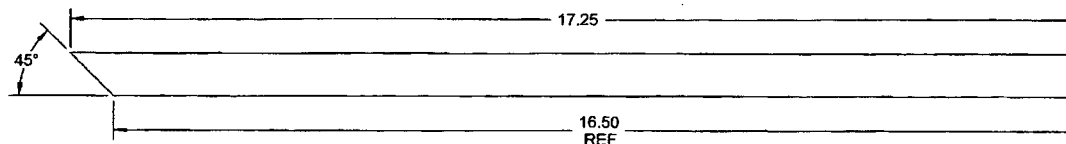
BREAK EDGE  
0.030 X 45°  
TYP



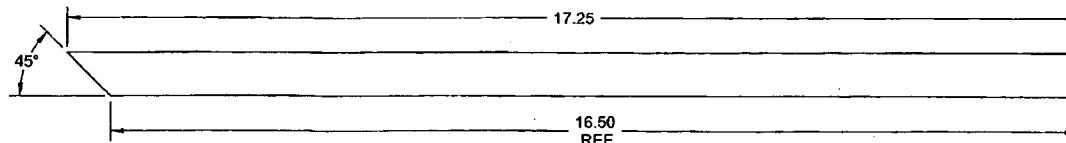
**SECTION A-A D4-4**



**D4034-3 RIB**



**D4034-5 RIB**



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3 & -5: 0.62 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 4 OF 4
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2011-01-10  
NW